

must ship July 30

Work Order ID 60786

Thursday, July 22, 2010 1:33:13 PM



Page 1

Item ID: D4151-3

Accept



Setup Start



Revision ID:

Item Name: Upper Hardpoint Plate

Stop



Start Date: 7/22/2010 Start Qty: 8.00



Required Date: 7/29/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/7/22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4151

PA1

B

10.07.22

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

Cut as per dwg D4151

Prog Rev: B

Dwg Rev: B

Deburr as required

813

10/07/27

(8)

(8)

10-7-26

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-7-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 60786

Thursday, July 22, 2010 1:33:13 PM

Page 2

Item ID:	D4151-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Upper Hardpoint Plate				Stop	
Start Date:	7/22/2010	Start Qty: 8.00		Cust Item ID:		
Required Date:	7/29/2010	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	S 1067127			(48)			
150  Packaging Packaging	Identify as per dwg & Stock Location: GA Memo B 60787	0.00 0.00	S 1067127			(8)			
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/07/28
10-7-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 1:33:17 PM

Page 1

Work Order ID: 60786

Parent Item: D4151-3

Parent Item Name: Upper Hardpoint Plate



Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	105.2383	0.055	0.463158			
304/316 0.125 Sheet												10-7-26	

Location

Loc Qty

Loc Code

MAT

105.2383

114488

1.5259

114799

103.7124

114799

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 60786
Description: UPPER HANDPOINT PLATE		Part Number: D4151-3
Inspection Dwg: D4151-3 Rev: B		Page 1 of 1

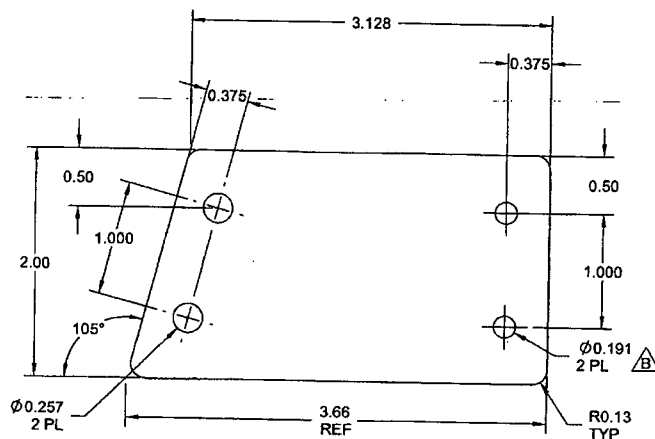
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

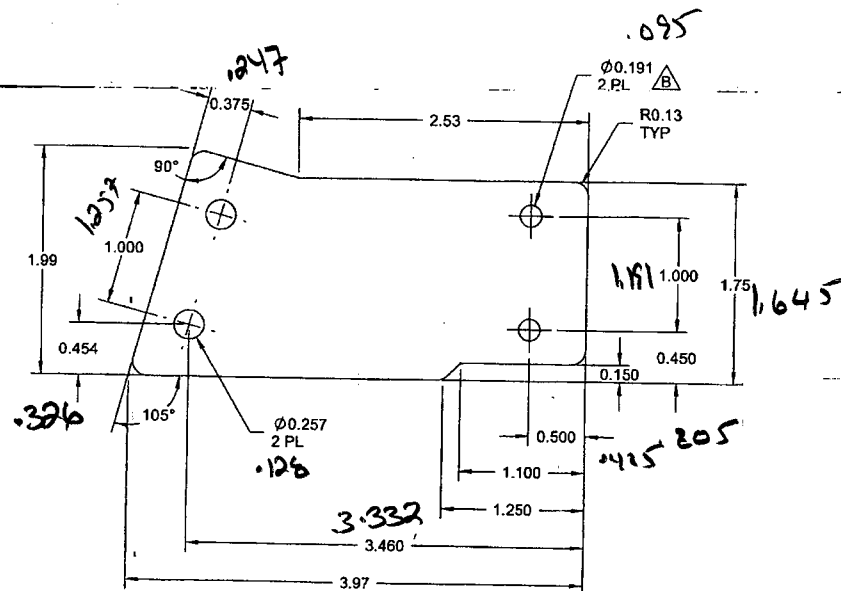
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+ .005 - .001	.192	X		vern HB-02	
Ø .257	+ .006 - .001	.258	X		u	
.375	± .010	.376	X		u	
2.53	± .030	2.53	X		u	
1.75	± .030	1.753	X		u	
1.000	± .010	.999	X		u	
.450	± .010	.450	X		u	
.150	± .010	.148	X		u	
.500	± .010	.501	X		u	
1.100	± .010	1.100	X		u	
1.250	± .010	1.250	X		u	
3.460	± .010	3.462	X		u	
3.97	± .030	3.97	X		u	
.454	± .010	.454	X		u	
1.000	± .010	.997	X		u	
1.99	± .030	1.99	X		u	
.125	± .010	.118	X		u	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-7-06	Date: 10/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



0.125
REF
D4151-1 LOWER HARDPOINT PLATE



0.125
REF
D4151-3 UPPER HARDPOINT PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. **60786**

BS10-7-28

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. B
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE NTS
DE APPR.			
DATE	10.07.05		

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.